

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025286**Date Inspected:** 18-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Trial Assembly 13W

This QA Inspector witnessed the in-process high strength bolt installation on bolts connecting the Rib Stiffeners to Rib Stiffeners at the bottom plate between longitudinal diaphragm (W4) to longitudinal diaphragm (W4) transverse splices between Panel Points (PP) 120 and (PP) 122.5, for Segment 13W bolting is in progress. U-rib stiffeners to U-rib stiffeners between W4 and W5 at PP120 to 124.5 Faying surface preparation in progress. The QA Inspector verified installation of the high strength bolts on a random basis and the results appeared to be in general compliance.

Trial Assembly 13E

Segment 13E was moved from trial assembly to the shipping boat via the 4000 ton barge crane. Note: that high strength bolting was not verified for final compliance prior to movement, this inspector did not receive any notification from ZPMC for a final high strength bolting tension verification at this time.

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## WELDING INSPECTION REPORT

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This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. All components were as listed on NWIT notification no. 09760. The member(s) is/are identified as OBG Barrier Rail components identified below with the following identifying weld no.(s):

1. E2-SKYWAY-001-003
2. E5-SKYWAY-001-003
3. W5-SKYWAY-001-001
4. W2-SKYWAY-001-001
5. W2-SAS-001-001
6. W5-SAS-001-001
7. E2-SAS-001-001
8. E5-SAS-001-001

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents



### Summary of Conversations:

Pertinent conversations are included in the body of the report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Hernandez,Rene

Quality Assurance Inspector

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**Reviewed By:** Hall,Steven

QA Reviewer